

Date: Thursday, 04/09/2008 1:23:21 PM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FITTING
Job Number	: 41828		
Estimate Number	: 10438		
P.O. Number	:	Part Number	: D32991
This Issue	: 04/09/2008 S.O. No. :	Drawing Number	: D3299 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 40301	Material	:
Written By	:	Due Date	: 30/09/2008
Checked & Approved By	: <u>JLD 08.9.04</u>	Qty:	20 12 Um: Each
Comment	: Est Rev:A 04.10.04 New issue KJ/JLM Est Rev:B 07-06-11 Removed Manual Machining & Hex Bar JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1250X01250	6061-T6 Bar 1.25 x 1.25
-----	--------------------	-------------------------



(19)

Comment: Qty.: 0.2013 f(s)/Unit Total: 2.4154 f(s)
6061T6 BAR 1.250" X1.250"
Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 1.250"X1.250"

M104554X2

Batch: M109068 X18

mmf 08/09/14

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



(19)

Comment: HARDINGE CNC LATHE SMALL
Cut blank: 2.200" long
Turn as per Folio FA451 and Dwg D3299

mmf 08/09/14

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



(19)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmf 08/09/14

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS

Machine as per Folio FA451 and Dwg D3299

CHAMFER PART USING CHAMFER MACHINE AS PER DWG D3299

Deburr

DIP 08/09/14 JLD

(19)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



(19)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DIP 08/09/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 04/09/2008 1:23:21 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 41828

Part Number: D32991

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

PHD
SP 08/09/20 (14)

7.0

OUTSIDE SERV.30

OUTSIDE SERVICES-MACH



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 7214

Anodize as per Dwg D3299

Possible Supplier: TNM Paint

Material release note is required

CO 08/09/20 (14)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

SP 8/9/20 (14)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 08/09/20 (14)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 82

8/10/20

SP

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/20 SP

Job Completion



MF 08-10-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3299-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>41828</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/9/22	# 40	During inspection it was found that qty (45) parts have unsatisfactory threading unsatisfactory threading R.C human error	Initial /08/10/22	Scrap and Destroy no Replace Qty (45)	DJP 08/09/24			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 41828
Description: Fitting		Part Number: D3299-1
Inspection Dwg: D3299	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	+/-0.030	1.24	✓			
0.476	+0.000/-0.005	.475	✓			
0.550	+/-0.010	.550	✓			
1.00	+/-0.030	.99	✓			
2.10	+/-0.030	2.09	✓			
0.773	+/-0.010	0.775	✓			
0.10	+/-0.030	.10	✓			
0.20	+/-0.030	.19	✓			
0.550	+/-0.010	.551	✓			
MOW Max = 0.573 Min = 0.565	Max = 0.573	.570	✓			
Ø0.302	+0.005/-0.000	Ø.302	✓			
Ø0.688	+0.005/-0.000	0.693	✓			
Ø0.580	+0.005/-0.000	0.581	✓			
53°	+/-0.5°	52°	✓			
1.09	+/-0.030	1.100	✓			

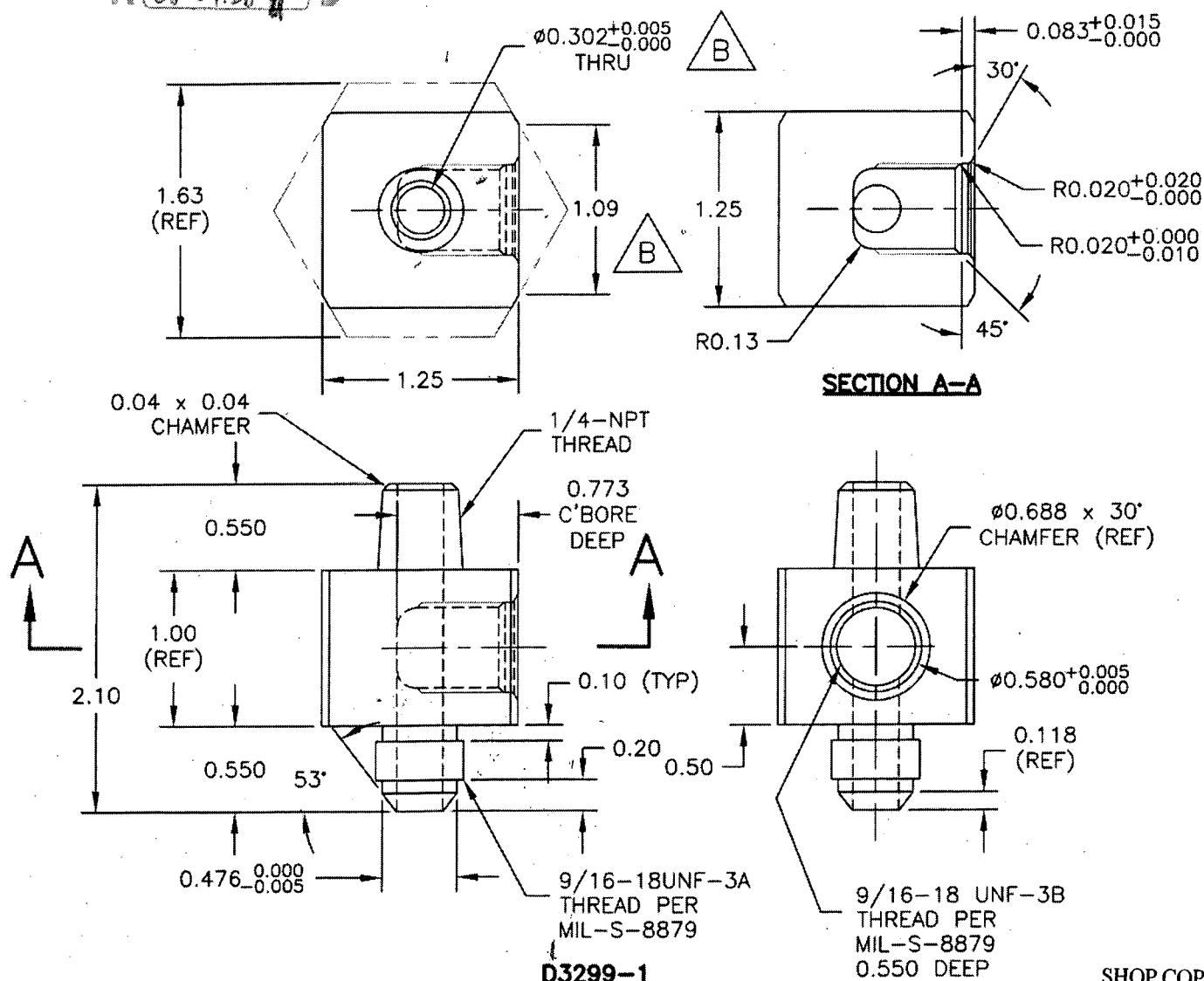
Measured by: JL	Audited by: [Signature]	Prototype Approval:	N/A
Date: 08/09/20	Date: 08/09/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.12	New Issue	KJ/JLM	
B	05.05.25	Ø0.302 was Ø0.312; 1.09 added	KJ/JLM	
C	08.07.23	Dwg Rev updated	KJ/DD	[Signature]



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3299	REV. B SHEET 1 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:1
A	04.07.06	NEW ISSUE	
B	05.04.28	1.09 WAS 0.837; $\phi 0.302$ WAS $\phi 0.297$	

RELEASED
05-04-28



D3299-1 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625) ENGINEERING
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS II POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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ENGINEERING

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 41828

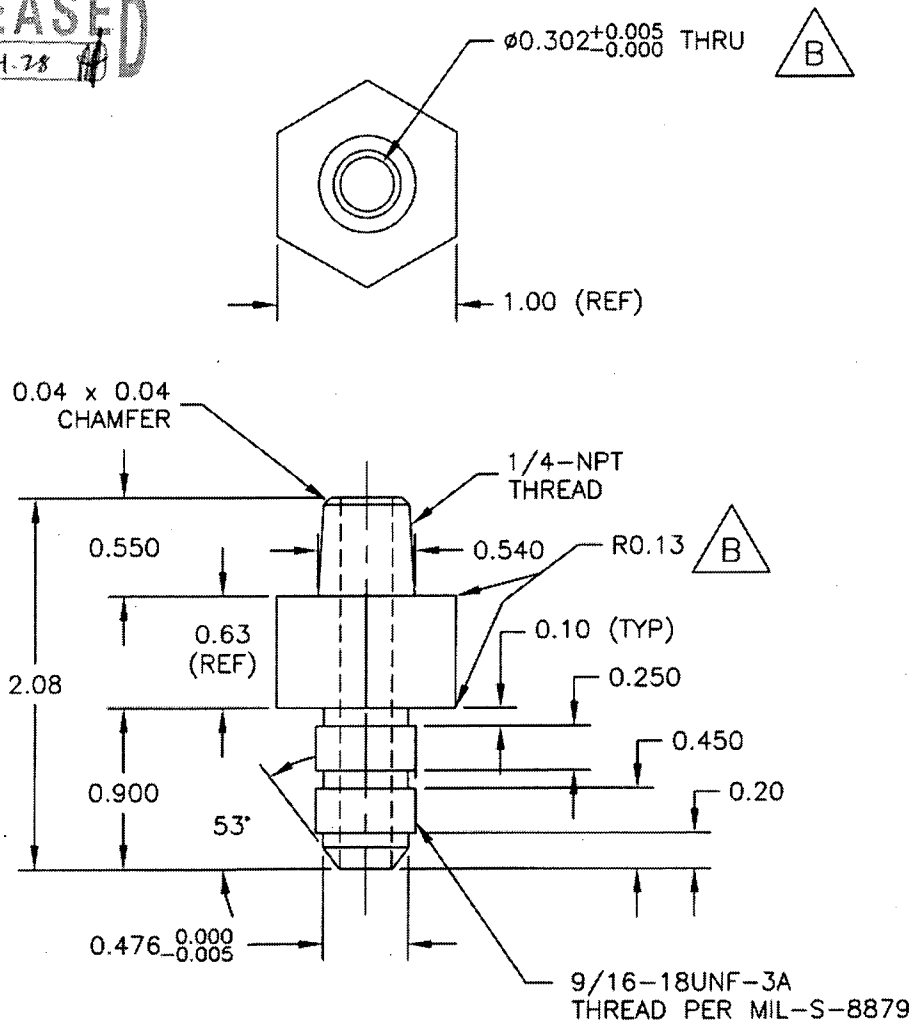
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3299	REV. B SHEET 2 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:1

RELEASED
05.04.28



D3299-3

D3299-3 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.00 HEX BAR (M6061T6H1.000)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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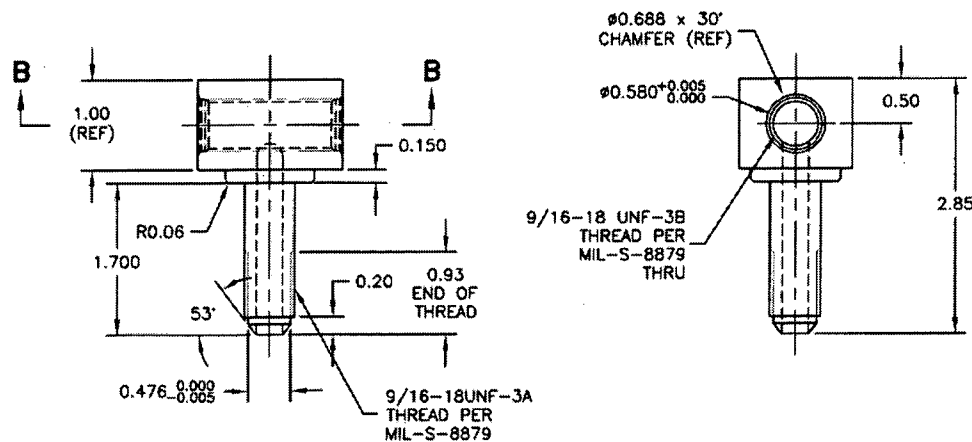
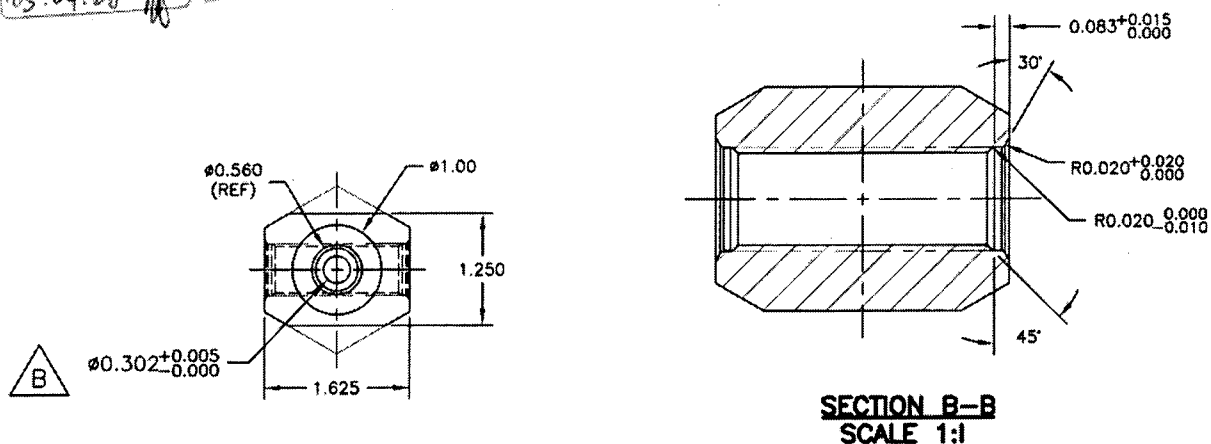
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CHECKED #	APPROVED #	DRAWING NO. D3299	REV. B SHEET 3 OF 3
DATE 05.04.28		TITLE FITTING	SCALE 1:2

RELEASED
05.04.28



D3299-5

D3299-5 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) 1.63 HEX BAR (M6061T6H1.625)
- 2) FINISH: BLUE ANODIZE PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
POSSIBLE SUPPLIER: ANODIZING TNM PAINT
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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TNM**ANODISATION et PEINTURE TNM INC.**

21 chemin de l'Aviation, Pointe-Claire, QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

Certifié NADCAP certified

FACTURE

INVOICE

68408 Rev.00

24-Sep-2008

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

NO. DE COMMANDE:
PURCHASE ORDER/ 7214**CONDITIONS / TERMS:****NET 30 JOURS / NET 30 DAYS**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER DESCRIPTION	PRIX UNITAIRE UNIT PRICE	EXTENSION
1	10	10	D2224 B41052 -	\$0.00	\$0.00
2	14	14	D3299-1 B41828 -	\$0.00	\$0.00
			MINIMUM CHARGE		\$220.00
SUB TOTAL:					\$220.00
TPS/GST:					\$11.00
TVQ/PST:					\$0.00
TOTAL AMOUNT DUE:					\$231.00

NMINIMUM CHARGE APPLIES

No de TPS / GST # : 891559734 RT

CERTIFICAT DE CONFIRMITE EMIS POUR CHAQUE PROCEDURE

No de TVQ / QST # : 1019307154 TQ000

CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS

En cas de perte ou de dommages dû a la valeur intrinsèque de certaines responsabilit  se limitera   deux fois la valeur du traitement des pieces perdues ou endommag es.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.

TNM**ANODISATION et PEINTURE TNM INC.**

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

approuvé NADCAP approved

68408

24-Sep-2008

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE****NO. DE COMMANDE: 7214
PURCHASE ORDER/**

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	10	10	D2224 B41052 -	RED ANODIZE PER MIL-A-8625F1 TYPE I CLASS 2
2	14	14	D3299-1 B41828 -	BLUE ANODIZE PER MIL-A-8625F1 TYPE I CLASS 2

S
08/10/01

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed: _____

Directeur de la Qualité / Q.A. Manager

